

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2016-35 Date Opened: 02-Mar-16 Title: FabricationAircraft OEM: Bell Aircraft Model: 429 Product Type: Fittings Product Model: Post S/N 81 Quantity: 1 set**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

N/A
N/A
JC
JC
N/A
JC
N/A
N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1 set
0
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
95940	0	Lug Fabrication	JC

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Traveller

Cut stock
Turn 1 end flat
Machine socket
Turn rounded end
Machine angled lug
Anodize

Initial or N/A

JC
JC
JC
DM
DM
JC

Work performed by:

Print: Jeff Clarke

Sign: 

SCA: AD02

Date: 13-Apr-16

ICC / Dual Inspection performed by:

Print: Jason Rekve

Sign: 

SCA: AD01

Date: 14-Apr-16

Work Order closed by:

Print: Jeff Clarke

Sign: 

SCA: AD02

Date: 27-Apr-16

Approved Manufacturing Facility 73-04

Form 20.D/03

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: LUG No. of pieces: 6

Manufacturer: AERO DESIGN LTD

Part No.: 95940-01/-02/-03/-04/-05/-06 Serial/Batch No.: 14092/15052

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-35

Remaining Tasks to be Performed: ANODIZE ✓ JK. 26 APR 2016

Signature: JK. Ceh.

Date: 15 APR 2016 Lic. No. / SCA AD02

In Process



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AMF 73-04

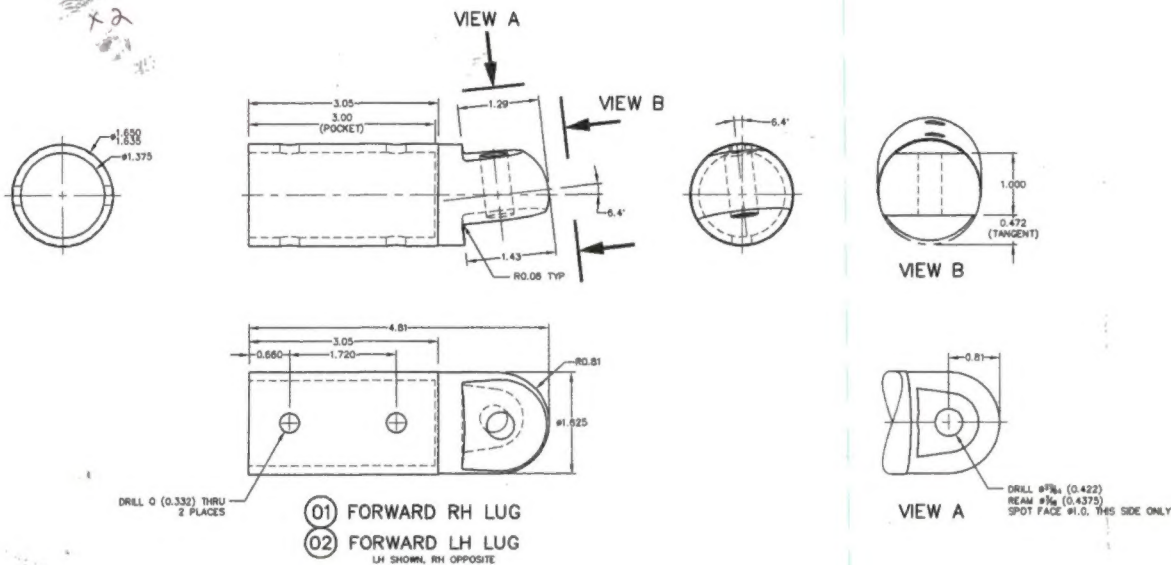
Remarks

In Process

2016-35

Cut stock @ 4.9

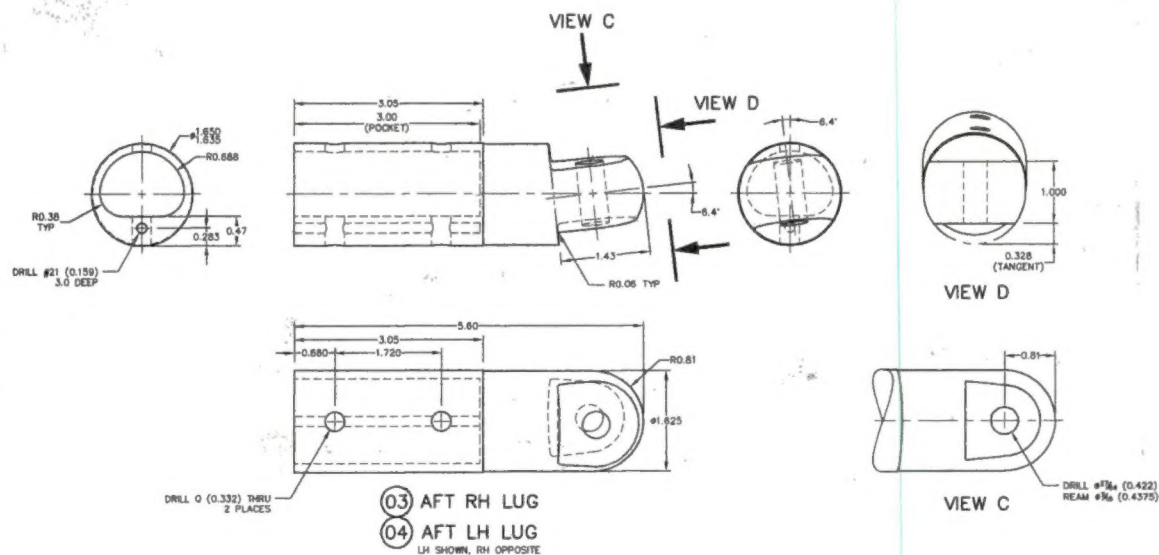
x2



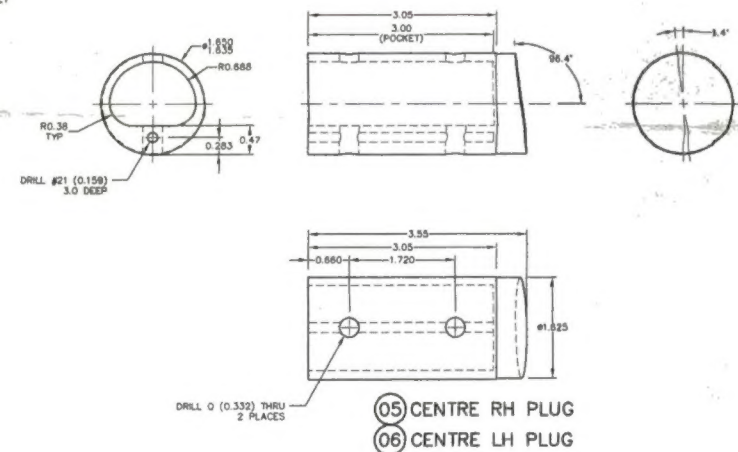
NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. THOROUGHLY DEGREASE, ALCOHOL AND EPOXY PRIME ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: ANODIZE IN ACCORDANCE WITH MIL-A-8625F, TYPE II.

Cut stock @ 4.0 x2



Cut stock @ 5.7 x2



QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	95940-06	06	CENTRE LH PLUG	6061-T6 ALUMINUM	QQ-A-200/B	#2.0 ROUND BAR
1	95940-05	05	CENTRE RH PLUG	6061-T6 ALUMINUM	QQ-A-200/B	#2.0 ROUND BAR
1	95940-04	04	AFT LH LUG	6061-T6 ALUMINUM	QQ-A-200/B	#2.0 ROUND BAR
1	95940-03	03	AFT RH LUG	6061-T6 ALUMINUM	QQ-A-200/B	#2.0 ROUND BAR
1	95940-02	02	FORWARD LH LUG	6061-T6 ALUMINUM	QQ-A-200/B	#2.0 ROUND BAR
1	95940-01	01	FORWARD RH LUG	6061-T6 ALUMINUM	QQ-A-200/B	#2.0 ROUND BAR

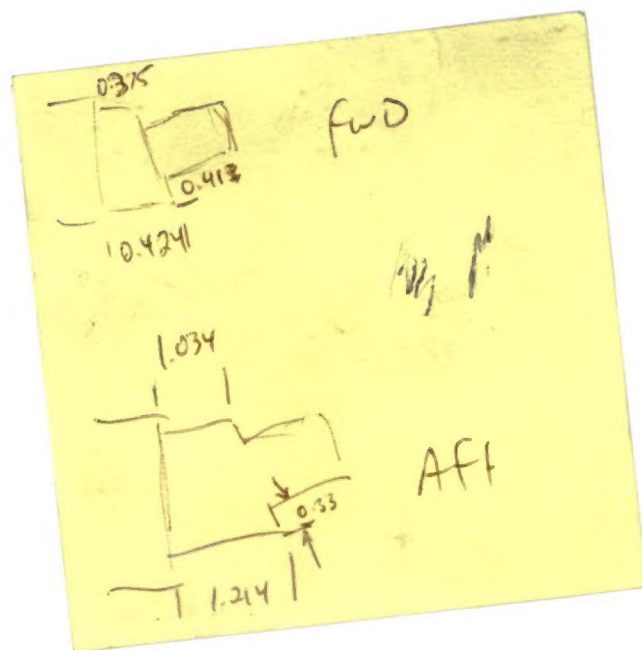
APPROVALS	DATE	DATE	DATE
DRAWN: JEFF CLARKE	21 JAN 2014		
CHECKED: JASON REDIVE	21 JAN 2014		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			
DECIMALS	ANGLES		
X.XXX ±0.010	±1/2°		
X.XX ±0.03			
X.X ±0.1			



AERO DESIGN LTD.

8088A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.685.3876 www.aerodesign.caBELL 429 - S/N 57081 & SUB.
QUICK RELEASE CARGO BASKET
LUG FABRICATION

SCALE	1:1	DWG NO.	REV.
SHEET 1 OF 1	A1	95940	0



3429 Post s/w 81 Fittings

Setup Notes

Rotate Vise 6.4° CW = LH CCW = RH

Rotate head towards operator 6.35°

* ensure head is aligned to Y axis *

Set \emptyset
X:



- 1 touch one side, set \emptyset X
- 2 touch other side (2.125 nom)
- 3 Split reading from 2 (1.063 nom)
Set \emptyset X

Set \emptyset Y



touch close side, set \emptyset Y

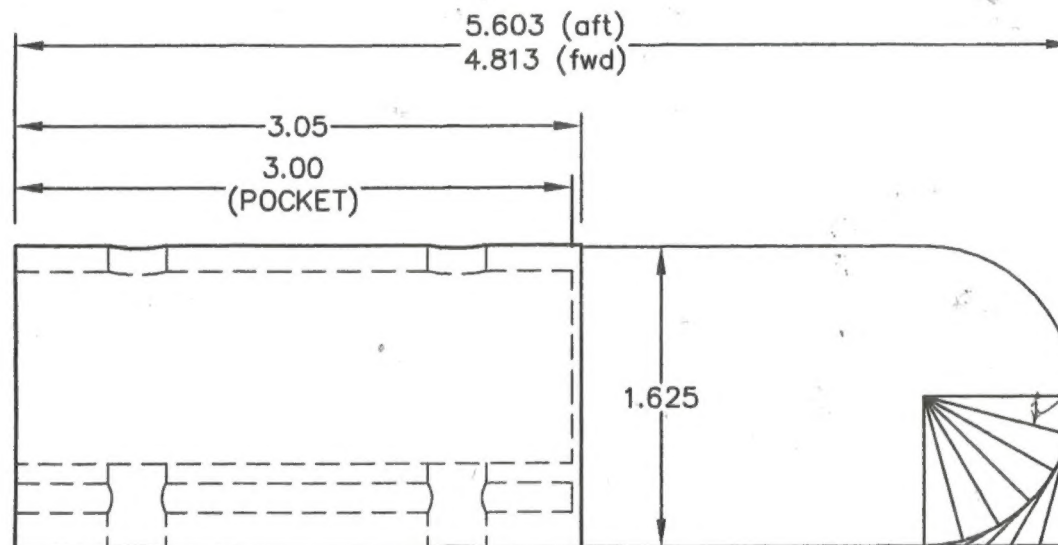
Set \emptyset Z



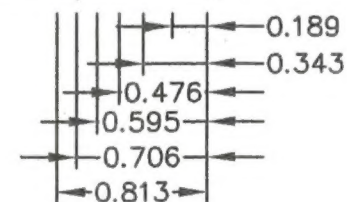
with cutter @ XO Y 1.063 touch
top.

- var 1 (2)
- cut paper to protect part from jaws of chuck.
 - wrap part with paper and insert into chuck.
 - set rpm to ~~1380~~ 40 rpm.
 - mark lines on part as per drawing @ .189", .343", .476", .595", .706" and .813" from faced end. using vernier calipers.
 - set rpm to 1380, set cross ~~slide~~ slide to 15° from 90° and make repeated cuts across face until you hit the first line at .189".
 - set cross slide to 30° from 90° and make repeated cuts across face until you hit the second line @ .343".
 - repeat this process for the rest of the lines advancing 15° each time.
 -

- Part (1)
- insert stop part into 1" collet.
 - cut paper to protect part from jaws of chuck.
 - wrap part with paper and insert into chuck.
 - set rpm to 1380.
 - turn end down to 1.625" for ~~full~~ length minus 3.05".
 - face end to length as per drawing.



15° increments
30°
45°
60°
75°
90°





WO# 2016-35

gc.
N/A - for
beams

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2016-0026
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2016-35
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Forward RH Lug	95940-01	1	N/A	New
2.	Forward LH Lug	95940-02	1		
3.	Aft RH Lug	95940-03	1		
4.	Aft LH Lug	95940-04	1		
5.	Centre RH Plug	95940-05	1		
6.	Centre LH Plug	95940-06	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature	AD 73-04 02	13c. Approved Organization Number AMF 73-04	14b. Signature	14c. Approved Organization Number	
13d. Name Jeff Clarke - AD02	13e. Date (dd/mmm/yyyy) 27 April 2016	14d. Name	14e. Date (dd/mmm/yyyy)		
Installer Responsibilities					
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

BEU PRAGUE